



Dart Aerospace Ltd.
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Canada

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D3913-041
Job Sheet 198563



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/9/19

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	9/9/19	9/9/19	0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		CL
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	9/9/19	9/9/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
							QC 9 - 50		9-89
120	QC 5	1 pcs	9/9/19	9/9/19	0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-89
							QC 5 - 58		



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Container No: S214712



Part: D3913-041

Job No: 198563

Serial No/Batch: S214712

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/18/19

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
125	Handfinish - 2-1 Pressure- B4B	1	9/9/19	0.00 0.29	Handfinish - 2 - 1 - B4B	BE B19-09-23
	pcs				Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)- B4B	1	9/9/19	0.00 0.93	Powdercoat - 1 - B4B	
	pcs				Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BE B19-09-24
					Powdercoat - 4 - B4B	
140	QC 3	1	9/9/19	0.00 0.00	QC 3 - 10	
	pcs				QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	BE B19-09-25
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150	Handfinish - 4-1-Assembly- B4B	1	9/9/19	0.00 0.50	Handfinish - 4 - 1 - B4B	
	pcs				Handfinish - 4 - 10 - B4B	MBE B19-09-25
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
160	QC 5	1	9/9/19	0.00 0.00	QC 5 - 10	

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		pcs				QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
170	Packaging 3-1 - Stock - B4B	1	9/9/19	0.00	0.00	Packaging 3 - 1 - B4B	
		pcs				Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
180	QC 21 - SA	1	9/9/19	0.00	0.00	QC 21 - SA - 21	
		pcs				QC 21 - SA - 70	
						QC 21 - SA - 53	

Part Op 100 - Weld per dwg A/R S.S. rod Batch: **3136920** 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to

- fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5200407
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5209116
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5184576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5209250
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5209290
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5190822
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5210886
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5209545
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5188182
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5183658
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5197557
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5212833
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5192406
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5213730
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5197525
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211019
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5206467
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5x5149264-2/1x3216929
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	586435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5202554
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5204283-2
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216748
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5188988
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

m.u. 012086

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	56	0
	D3913-1	1	6	0
	D3913-15	1	20	0
	D3913-3	1	6	0
	D3913-7	2	14	0
	D3913-9	1	9	0
	D3916-041	2	2	0
	D3916-5	3	8	0
	D4016-1	3	28	0
	D4017-7	3	40	0
	D4017-9	2	12	0
	D4020-11	2	6	0
	D4021-1	3	28	0
	D4034-041	1	2	0
	D4034-043	1	8	0
	D4672-1	2	7	0
	M304EX0.75-16F	32	561	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	142	0
	D2931	2	687	0
	D4021-5	2	32	0
	MS20600-AD4W3	2	880	0
	MS21042L3	6	856	0
	NAS1149F0332P	12	2,290	0
	NAS1149FN832P	2	1,764	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging ☐ Engineering Water Jet Supplier Quality ☐ ☐ ☐		DEPARTMENT/PROCESS Cross tube Small Fab Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging ☐ Engineering Water Jet Supplier Quality ☐ ☐ ☐		MRB (QSI042) ☐	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
Completed By _____		Lead hand / Supervisor _____					
QC / QA Coordinator _____		Other/Details: 					